

Work Order ID 140701

Thursday, January 14, 2016 8:42:05 AM

140701

Page 1

Item ID: D4016-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Half, Lid
 Start Date: 1/14/2016 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 1/14/2016 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JAN 14 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4016	A								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00				40	0		<u>16/01/14</u>
Jeaspa Bandsaw	CUT BLANK as per folio								
110		0.00							
110									
HAAS 1	Memo	0.22				40			<u>16/01/14</u>
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA874 AND DWG FOLIO REV: <u>AA</u> DWG REV: <u>A</u> DEBURR								DAS 44 9-89 <u>16/01/18</u>

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Thursday, January 14, 2016 8:42:05 AM

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Page 3

Item ID: D4016-3 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Hinge Half, Lid
Start Date: 1/14/2016 Start Qty: 40.00 ***40*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

Quality Control

ML3

JAN 19 2016

SA 20160119

Picklist Print

Thursday, January 14, 2016 8:42:11 AM

Page 1

Work Order ID: 140701

140701

Parent Item: D4016-3

D4016-3

Parent Item Name: Hinge Half, Lid

Start Date: 1/14/2016

Required Date: 1/14/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased		No		100	f	16.6950	0.08	3.368421			
M304B1 000X1 000										**		16/01/15	
304 bar 1.00 x 1.00													

Location

Loc Qty

Loc Code

MAT009

16.695

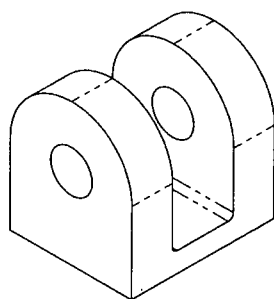
M133560

4.695

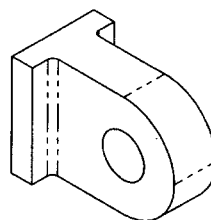
M133889

12

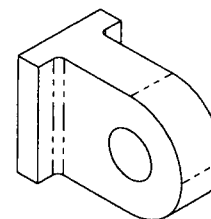
3,54'



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

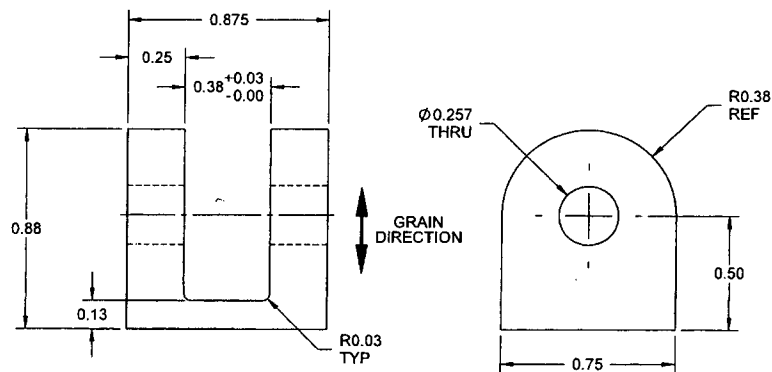


D4016-5 HINGE HALF, LIGHT LID

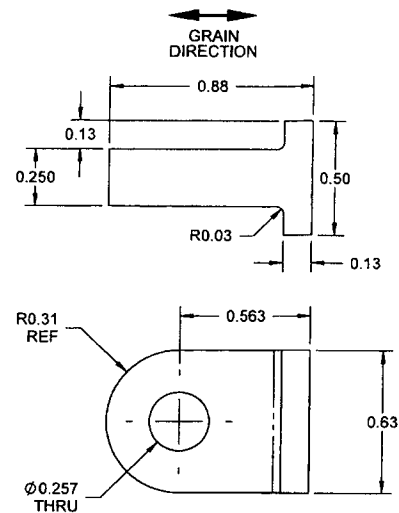
SHOP COPY
 RE-PRINTED
 UNCONTROLLED COPY
 SIGNED BY: [Signature]
 DATE: 16-01-14

RELEASED
 2010-02-16
 [Signature]

A		NEW ISSUE		JPH		10.01.29	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 2	
DRAWN	AJS						
CHECKED	[Signature]	DRAWING NO. D4016		TITLE		SCALE	
MFG. APPR.	[Signature]	BASKET HINGE		NTS		DATE 10.01.29	
APPROVED	[Signature]						
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

RELEASED
2010-02-16

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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